

Date: Tuesday, 15/07/2008 9:20:18 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FLOAT SKIDTUBE
<b>Job Number</b>	: 40504		
<b>Estimate Number</b>	: 10366		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D412742013
<b>This Issue</b>	: 15/07/2008 <b>S.O. No.</b> :	<b>Drawing Number</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b>	: D
<b>Previous Run</b>	: 40502	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 15/08/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JLD 08/15/08</u>		
<b>Comment</b>	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DS19336 JLM Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*CL 08/09/15 label red + white*

*S*



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013

CHG004

*005*

*ECN 08/510*

2.0	40504A	FLOAT SKID ASSEMBLY
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Comment: Sub-Component FLOAT SKID ASSEMBLY

1 x D412-742-043

Batch

*40504A*

*SLP*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2571	Saddle, Fwd Out 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2571

Saddle Fwd Outside

*B39806*

*SLP*

5.0	D2572	Saddle, Fwd In 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2572

Saddle Fwd Inside

*B40085*

*8/9/11*

*SLP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:20:18 AM  
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Drawing Name: FLOAT SKIDTUBE

Job Number: 40504

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D2573 Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2573 Saddle Aft Outside B398008

scf

7.0 D2574 Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2574 Saddle Aft Outside B40199

scf

8.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2876 Saddle Spacer B36275

scf

9.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2877 Saddle Spacer B36276

scf

10.0 D34031 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch  
16 D3403-1 Bushing B37547

(13)  
B39984

scf

11.0 D2747 Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
4 D2747 Bolt B39224

6/9/12

scf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40504

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D35331	Set Screw
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B28093



sf

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Set Screw

13.0	AN4C6A	Bolt
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
16 AN4C6A Bolt M107242

sf

14.0	AN4C52A	BOLT
------	---------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
8 AN4C52A Bolt M105423

sf

15.0	AN6C12A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
8 AN6C12A Bolt M104289

sf

16.0	D36723	Phenolic Washer
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sf

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)  
PHENOLIC WASHER

17.0	AN960C416L	WASHER
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sf

Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)  
WASHER

18.0	D36729	Phenolic Washer
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sf

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PHENOLIC WASHER

8/9/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FLOAT SKIDTUBE

Job Number: 40504

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C616L

WASHER



M107242



54

Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
WASHER

20.0

D367211

Phenolic Washer



B35524



54

Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
PHENOLIC WASHER

21.0

MS210434

Nut



11

M108672

13

M109148



54

Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)  
Nut

22.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: M106302

54

23.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
8 D3403-3 Bushing B39150

8/9/12

54

24.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
1 D3405-041 GHW Lug B35779

54

25.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
1 D3405-043 GHW Lug B34841

8/9/14

12

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 40504

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M101467

50

27.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M108672

54

28.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

B410529

50

29.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

M33519

54

30.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

M340285

54

31.0

AN3C37A

BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

106169

8/9/12

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40504

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	AN3C40A	BOLT
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M106169



sq

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOLT

33.0	AN3C41A	BOLT
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M108084



sq

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOLT

34.0	AN3C42A	BOLT
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M106169



sq

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOLT

35.0	AN3C43A	BOLT
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M106227



sq

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT

36.0	AN3C46A	BOLT
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M106169



sq

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)  
BOLT

37.0	AN960C10L	washer
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M108255



sq

Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)  
washer

38.0	MS210433	Nut
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M109147



ⓧ

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)  
Nut

8/9/11

sq

39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08.10.01 ①  
Everything in the box.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/07/2008 9:20:18 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 40504

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



50

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: GA

8/10/1

(12)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/07/2008 9:20:32 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FLOAT SKID ASSEMBLY
<b>Job Number</b>	: 40504A		
<b>Estimate Number</b>	: 10756		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D412742043
<b>This Issue</b>	: 15/07/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3391
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 40502A	<b>Drawing Revision</b>	: G
	<b>Type</b> : SKIDTUBES	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 15/08/2008
<b>Checked &amp; Approved By</b>	: <u>NO 08.15.08</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

N/A *Handwritten signature*

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 \_\_\_\_\_

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 \_\_\_\_\_

Expiry date: \_\_\_\_\_

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exopt ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon \_\_\_\_\_

A/R Sikaflex-241/-291 \_\_\_\_\_

Expiry date: \_\_\_\_\_

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

*Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-742-043 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: Yes Date: 08/10/03  
 QA: N/C Closed: Yes Date: 08/10/03

NCR: <u>40504 A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-09-15</u>	<u>2</u>	<u>WEARPLATE HOLE ON MID-TUBE PORTION THAT MATES WITH FWD TUBE IS @ WRONG ANGLE</u>	<u>PA</u> <u>08-09-15</u>	<u>OPEN HOLES TO ALLOW FOR FIT. HOLE SIZE REQ'D <math>\phi</math> 0.300 ACCEPTABLE DEVIATION</u>	<u>PA</u> <u>08-09-15</u> <u>QSI</u> <u>042</u>	<u>S</u> <u>08/10/03</u>	<u>PA</u> <u>08-09-15</u> <u>QSI</u> <u>042</u>	<u>S</u> <u>08/10/03</u>

NOTE: Date & initial all entries



Date: Friday, 08/08/2008 10:19:58 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLOAT SKID ASSEMBLY
<b>Job Number</b> :	40504A		
<b>Estimate Number</b> :	10756		
<b>P.O. Number</b> :		<b>Part Number</b> :	D412742043
<b>This Issue</b> :	08/08/2008	<b>Drawing Number</b> :	D3391
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	15/07/2008	<b>Drawing Revision</b> :	G
<b>Previous Run</b> :	40502A	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	15/08/2008
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev C 07-05-28 As per Rev F JLM Est Rev D 07-12-04 ECN 1072 DD verified by:JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

\*\*CLEAN-DO NOT SPRAY LPS  
 FORWARD TUBE TO SKIDTUBE CELL  
 PER DSI 9364\*\*\*

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391  
 A/R LPS-3 M107912

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M108801  
 Expiry date: 08/10

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.  
 A/R LPS Procyon M104251  
 A/R Sikaflex-241/-291 M108801  
 Expiry date: 08/10

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

PTO  
 →  
 M-1  
 08/09/15

Step 2

Date 08.09.15

Identify hole on mid-tube portion that makes with find tube is @ wrong angle

OPEN HOLES TO ALLOW

FOR AIR

HOLE SIZE 0.300

ACCEPTABLE

DEVIATION

08.09.15

BT

Date: Friday, 08/08/2008 10:19:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40504A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

A) - DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B *41140*

*DP 8-9-13*

B) - DEBURR ALL HOLES

- TOUCH UP ALODINE

- TOUCH UP PAINT

C) - RECOAT WITH LPS3 B

*M107912 / m-k 08/09/15*

RETURN TUBE TO HAND FINISHING

-CONTINUE ON ASSEMBLY PER SEQ 2.0

3.1

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing

*DP 8-9-13*

Job Completion



Date: Tuesday, 15/07/2008 9:20:32 AM  
User: Julie Lecocq

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Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40504A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly

B41746 m-h

4.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-025 Aft Tube Assembly

B40526 m-h

(PO) →

5.0

D35641

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B40988 m-h

\*

6.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch:

B41466 m-h

\*

7.0

D35643

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

B34052 m-h

\*

8.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

B41464

(IX)

m-h 08/09/15

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-742-043 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: D Date: 08/18/15  
QA: N/C Closed: D Date: 08/18/15

NCR: 40504 A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/18/15	4.0	During assembly employee strikes a AELS-1032-225 insert. Qty 2 After Removing employee noticed that he has scored the aft tube through the Powder coat into the Bare Aluminum.	[Signature] Posium	Scrub Powder coat scratches with 320g.	M-1 08/04/15	Scrub 08/18/15	[Signature] Posium	[Signature] 08/18/15
				Re alcohol as per QST-005 Remove All LPS tube. Re Powder coat as per QST-005 (Plug remaining inserts with Bolts)	08/04/15 08-04-15 (YI)	Scrub 08/18/15		
				Inspect Qc3	M-1 08/04/15	Scrub 08/18/15		

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:20:32 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40504A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35665

Gasket



*[Handwritten mark]*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: \_\_\_\_\_

*B41467*

*m-l*

10.0

AN3C4A

BOLT



*[Handwritten mark]*

Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: \_\_\_\_\_

*M109148*

*m-l*

11.0

AN3C6A

BOLT



*[Handwritten mark]*

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: \_\_\_\_\_

*M105300*

*m-l*

12.0

AN3C7A

BOLT



*[Handwritten mark]*

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: \_\_\_\_\_

*M107376*

*m-l*

13.0

AN960C10L

washer



*08-10-01*

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: \_\_\_\_\_

*M109147*

*(38X)*

*M108255*

*(6X)*

14.0

QC5

INSPECT WORK TO CURRENT STEP



*[Handwritten mark]*

Comment: INSPECT WORK TO CURRENT STEP

*508/08/45 (41)*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



*34*

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*PPP 40504*

*8/10/1*

*(15)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/19/15	1							

**NOTE:** Date & initial all entries

Date: Tuesday, 15/07/2008 9:20:32 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 40504A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/03 *ag*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF* 08-10-02



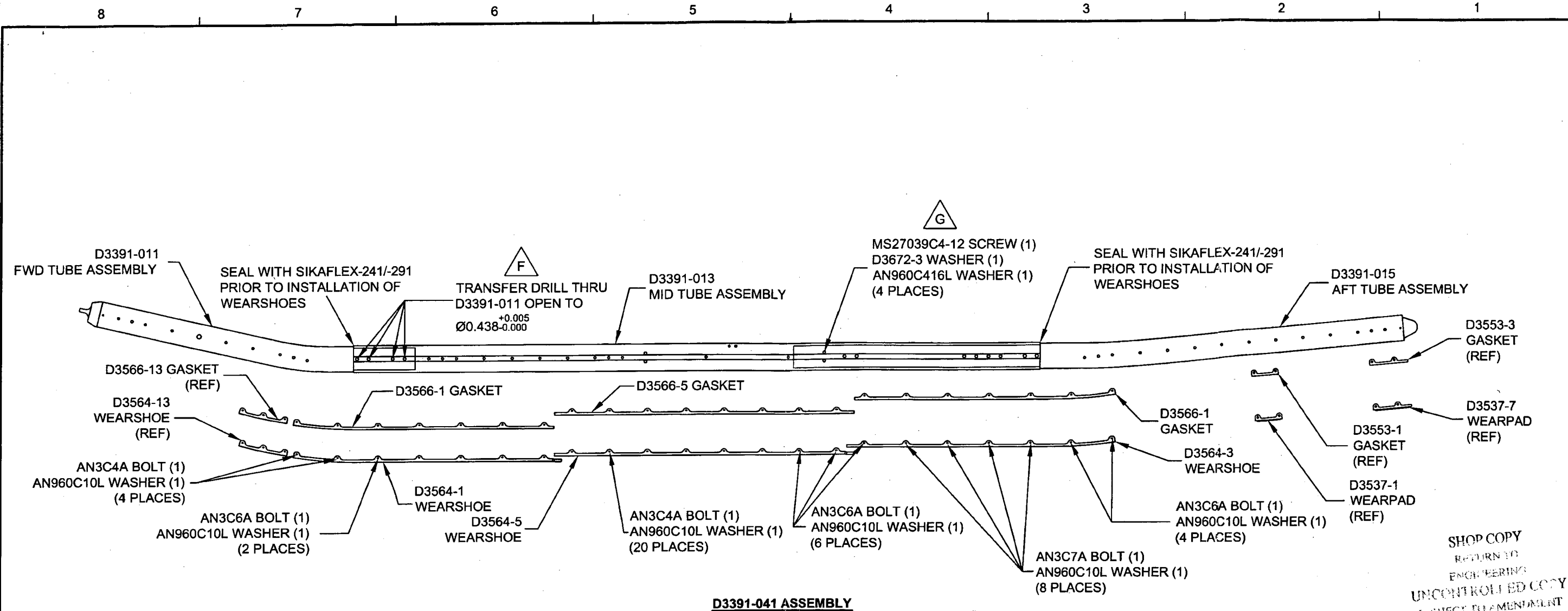
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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27-11-06 MP

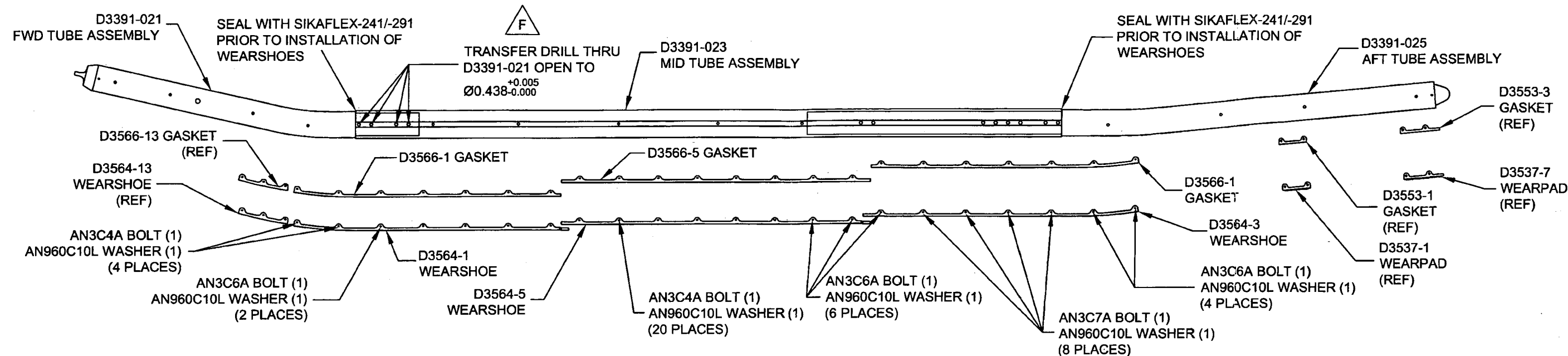
# D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

## GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.07.31		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA DRAWING NO. D3391 REV. G SHEET 1 OF 8 TITLE 412 FLOAT SKIDTUBE SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



**D3391-043 ASSEMBLY**

**RELEASED**  
07.11.21

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

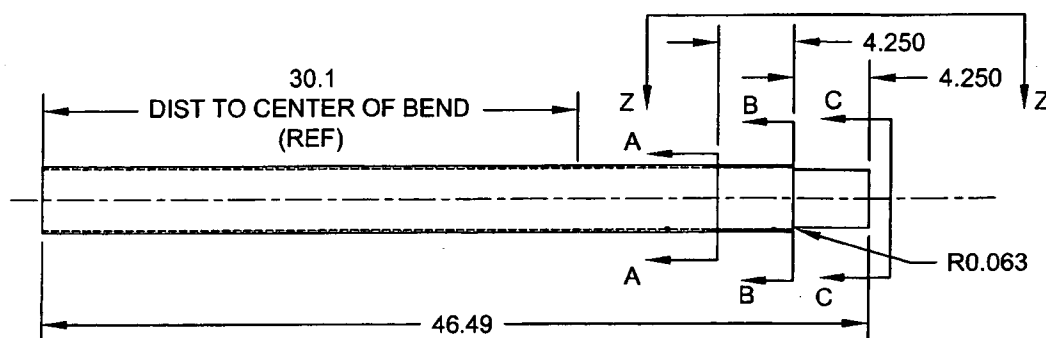
QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

**GENERAL NOTES**

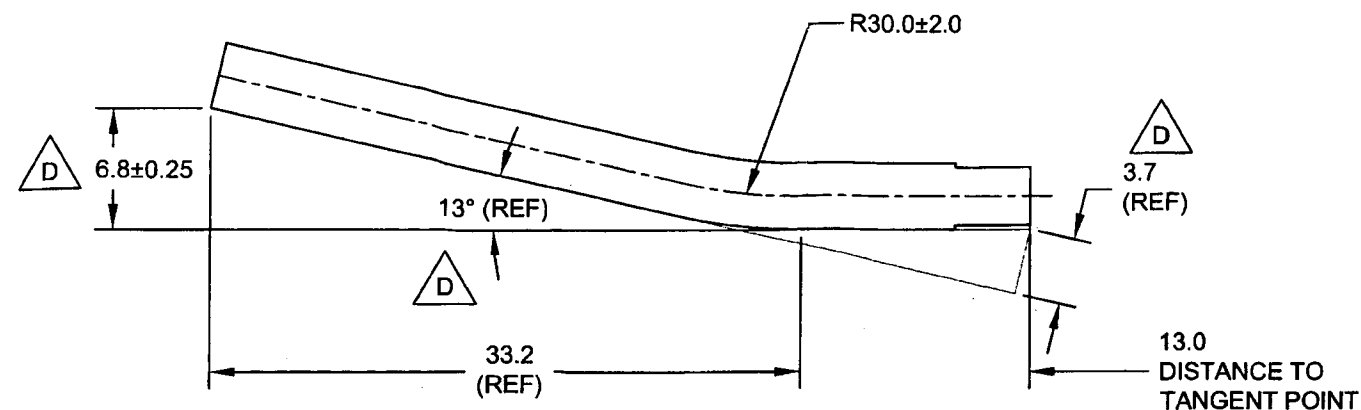
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

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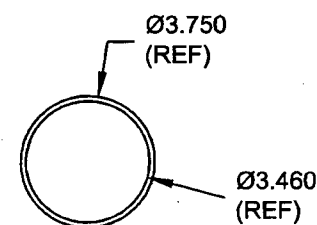
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MFG. APPR.	JLC	D3391	SHEET 2 OF 8
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DE APPR.	JLC	412 FLOAT SKIDTUBE	NTS
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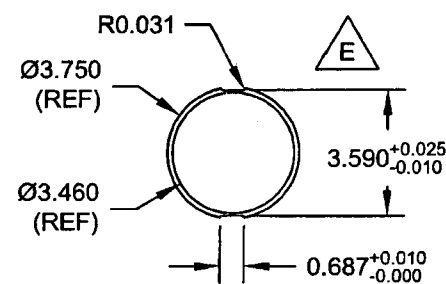
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



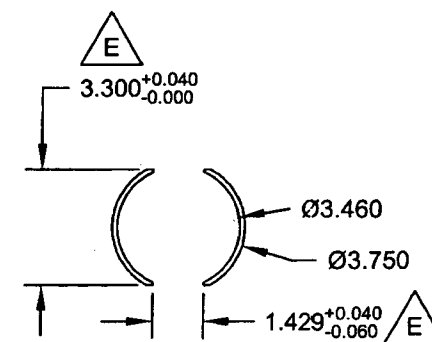
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



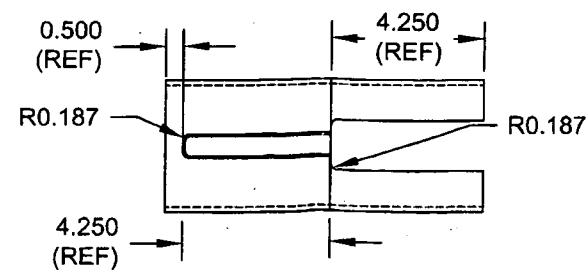
**SECTION A-A**  
(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)

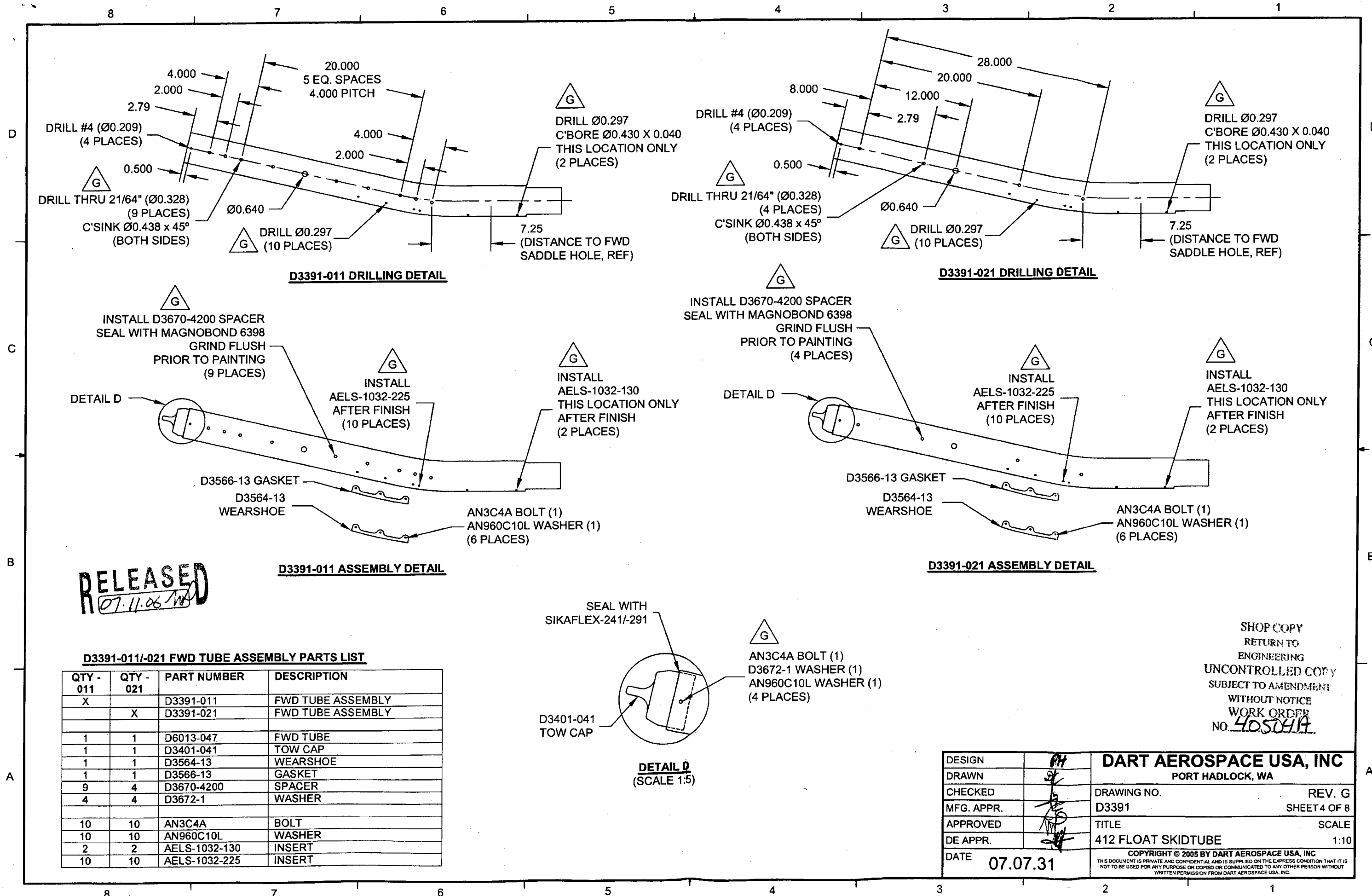


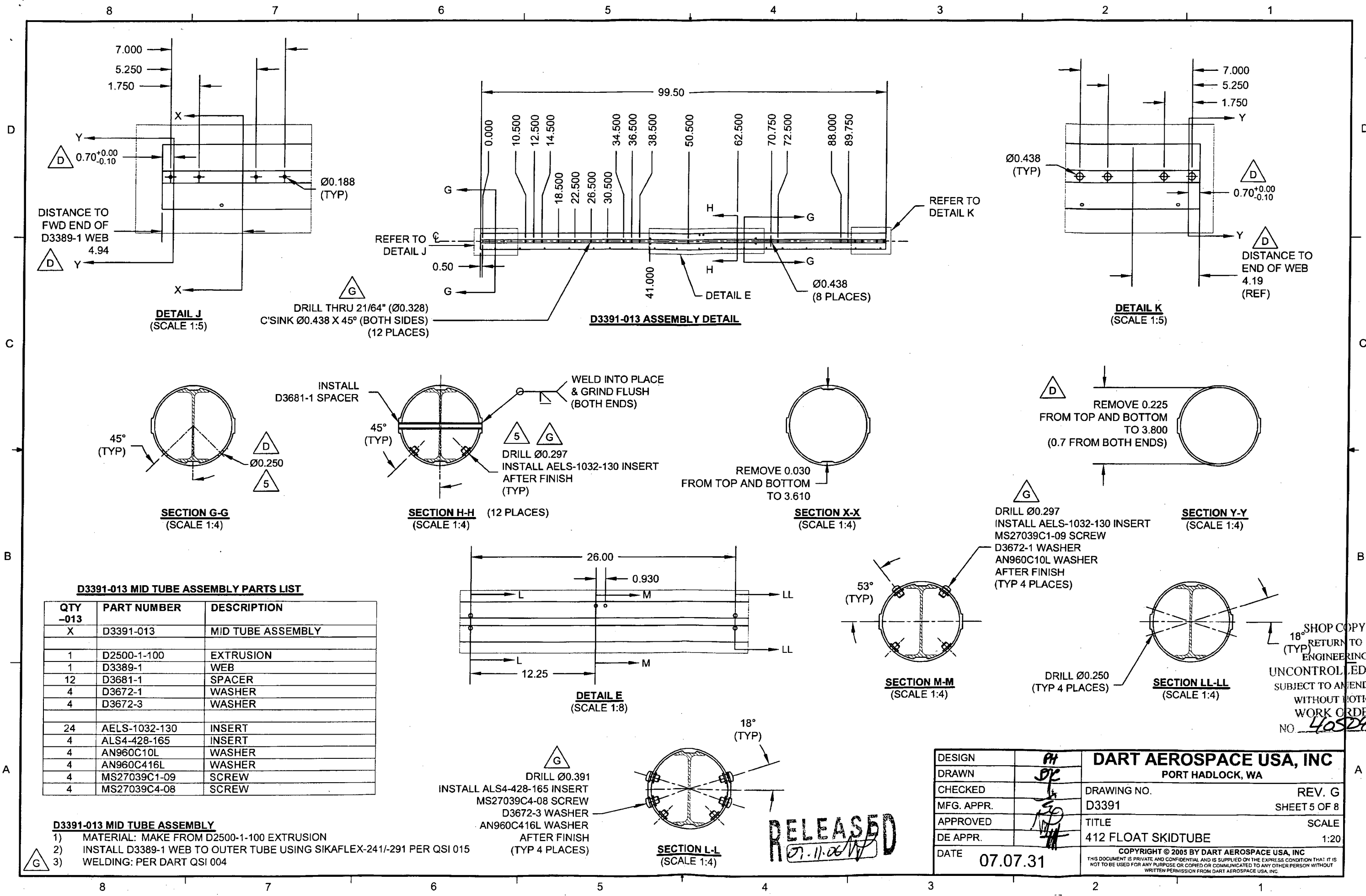
**VIEW Z-Z**  
(SCALE 1:5)

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**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
  - 3) WELDING: PER DART QSI 004

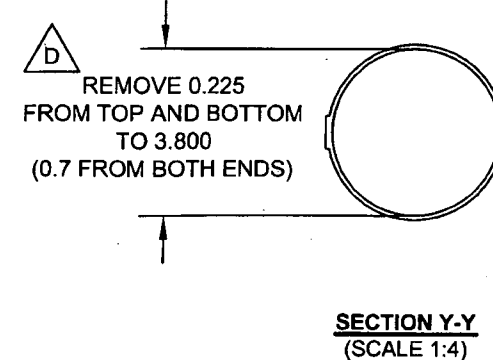
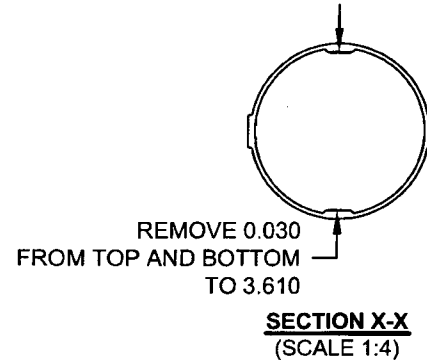
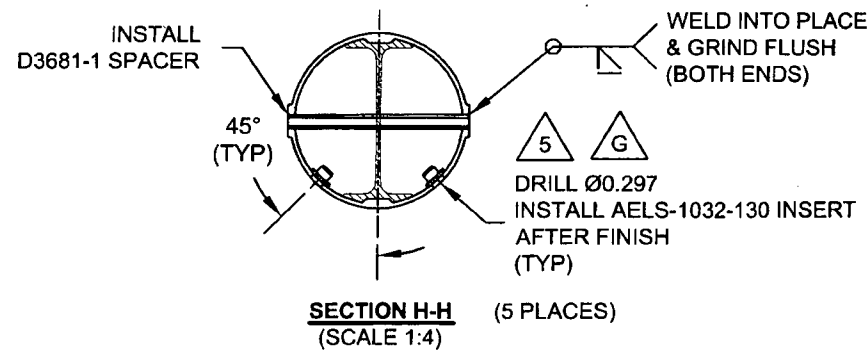
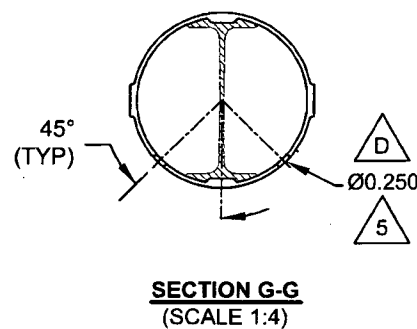
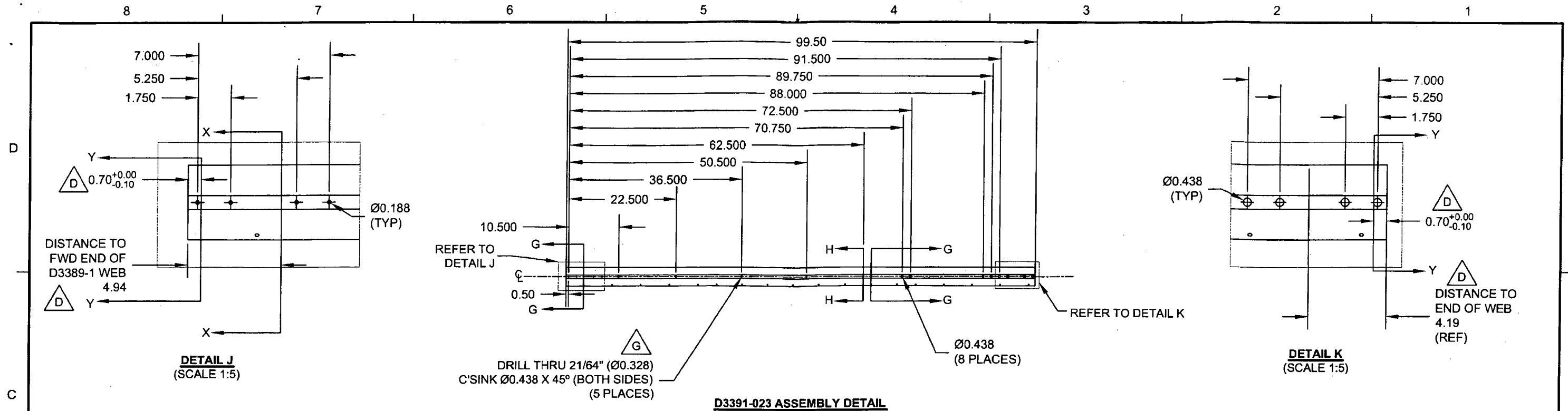
DRILL Ø0.391  
 INSTALL ALS4-428-165 INSERT  
 MS27039C4-08 SCREW  
 D3672-3 WASHER  
 AN960C416L WASHER  
 AFTER FINISH  
 (TYP 4 PLACES)

**SECTION L-L**  
 (SCALE 1:4)

**RELEASED**  
 07.11.06

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MFG. APPR.		D3391	SHEET 5 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	1:20
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**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

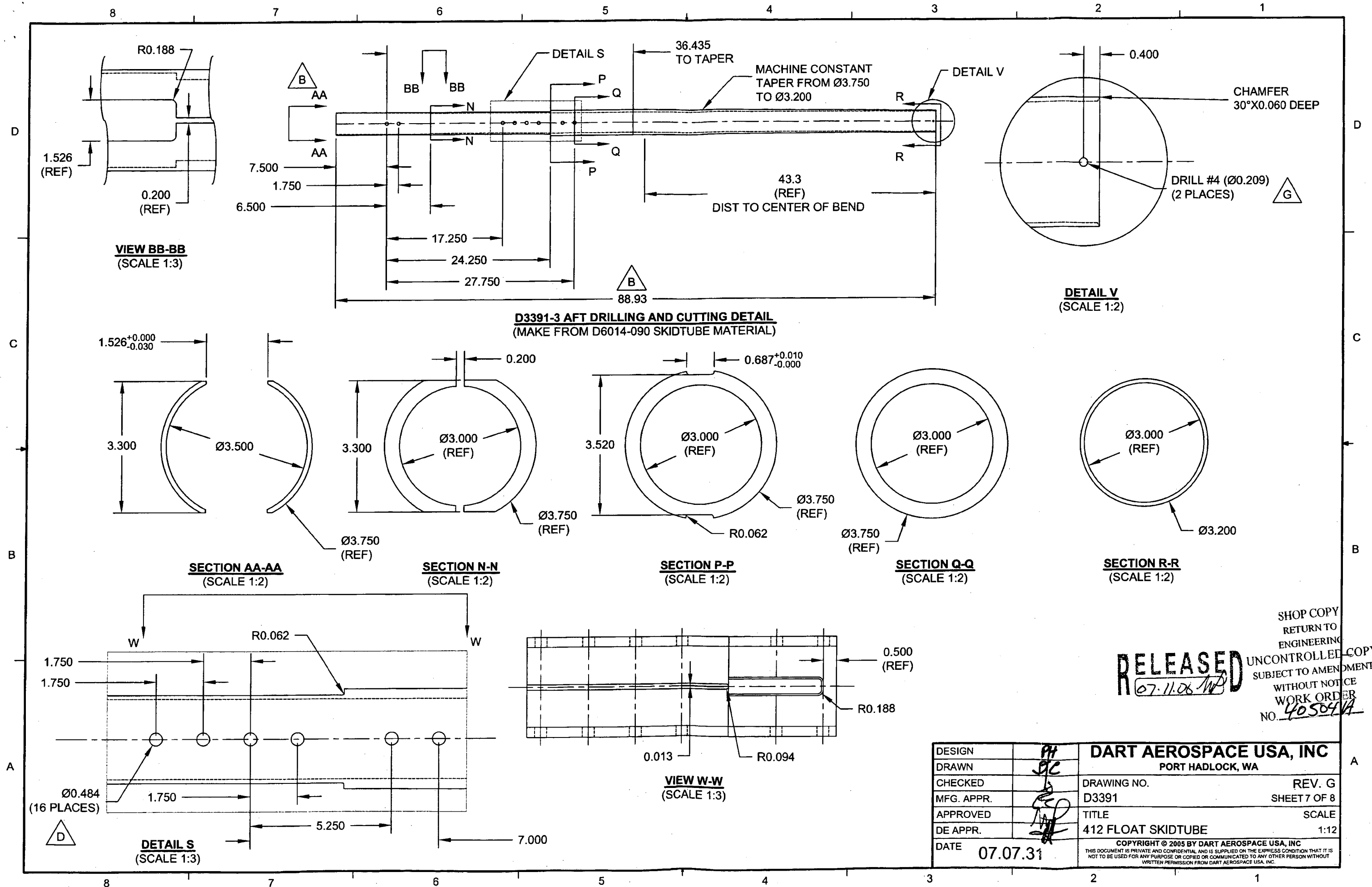
**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

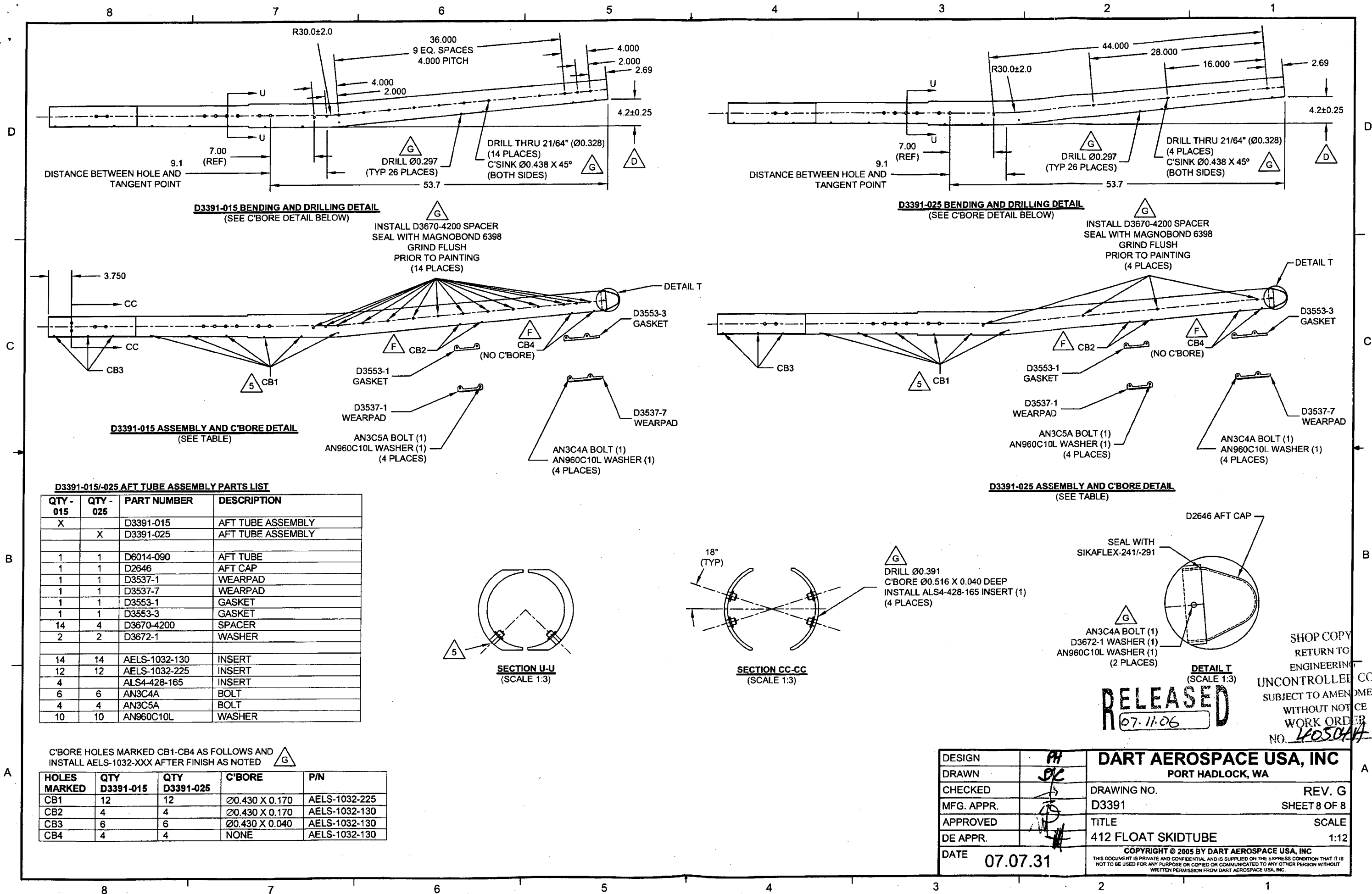
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07.11.06/11

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CHECKED	J	DRAWING NO.	REV. G
MFG. APPR.	RED	D3391	SHEET 6 OF 8
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DE APPR.	SH	412 FLOAT SKIDTUBE	1:20
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REFERENCE ONLY

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06		TITLE BUSHING INSTALLATION	SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY	

REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. D AND ICA-D412-742 REV. 3

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

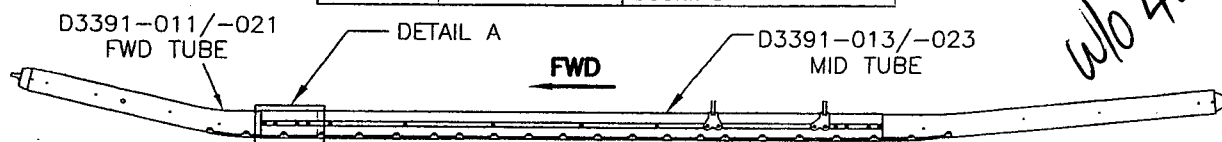
REF EASA STC: IM.R.S.01126

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

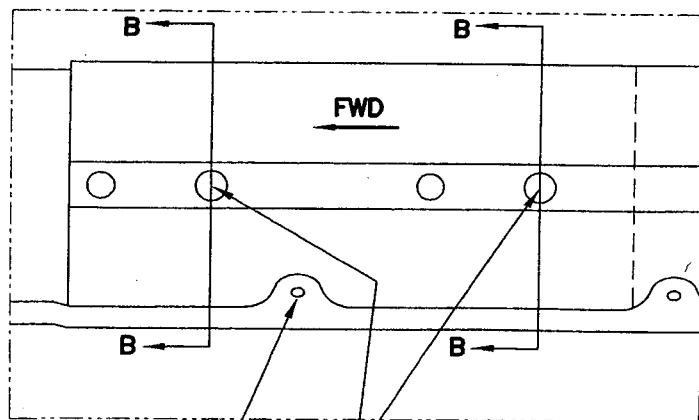
CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ( $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$ ) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



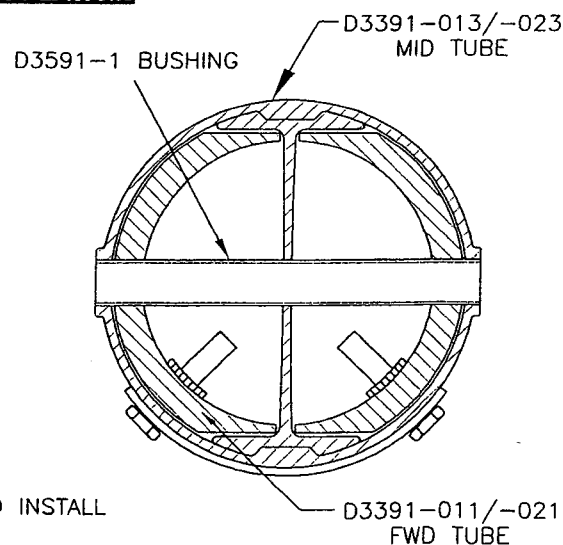
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO  $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$  AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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